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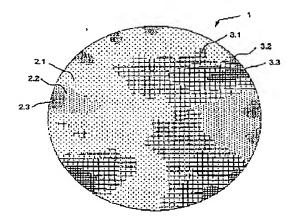
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## (54) Title: CORRECTION METHOD FOR CHIP REMOVAL MACHINES



## (57) Abstract:

The invention concerns a method for determining a deviation of at least one regulating variable on chip removal machines with a mechanical drive for a tool and/or a workpiece 1, regulated by a control system, wherein the regulation comprises a plurality of values C, X, Z of at least three spatial axes c, x, z for the control system and for the drive, and the values C, X, Z have a functional relation such as  $Z = f_{bi}$  (C, X) with the axes c, x, z. A protocol is prepared from a plurality of control system actual values ( $C_{p,s}, X_{p,s}, Z_{p,s}$ ) detected by measuring means and/or selected drive actual values ( $C_{p,a}, X_{p,a}, Z_{p,a}$ ) and a control system nominal value according to  $Z_{bi,s} = f_{bi}$  ( $C_{p,s}, X_{p,s}$ ) and/or a drive nominal value according to  $Z_{bi,a} = f_{bi}$  ( $C_{p,a}, X_{p,a}$ ) is calculated at least in relation to the z-axis, and a control system differential value according to  $D_{z,s} = Z_{p,s} - Z_{bi,s}$  and/or a drive differential value according to  $D_{z,a} = Z_{p,a} - Z_{bi,a}$  is calculated at least in relation to the z-axis. The invention also pertains to a chip removal machine which implements such a method.

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